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(54) TIP AND CUTTER FOR INTERNAL PIN MIRROR

(57)Abstract:

PROBLEM TO BE SOLVED: To provide a tip and a cutter for an internal pin mirror of excellent cutting performance by setting a cutting rake angle to a positive angle, using a vertical insert type tip.

SOLUTION: Chamfers 81 of circular arc shape with a radius R1 are additionally provided along the short sides 71 of a parallelogram from the upper face 2 of the tip 1. Further, the corners 9 of obtuse angles are additionally provided with chamfers 82 of circular arc shape with a radius R2 along the short sides 72 of an imaginary parallelogram with the corners of larger obtuse angles than the obtuse angles of the corners 9. The long sides 3 are formed as side faces 5 with relief angles θ . Two kinds of tips 1 in different specification are used and mounted to the cutter 10 so that the corners of the radius R1 coincide with the corners of a pin part and that the corners of the radius R2 coincide with the corners of a shoulder part, thus forming a cutting edge for cutting a crankshaft.

